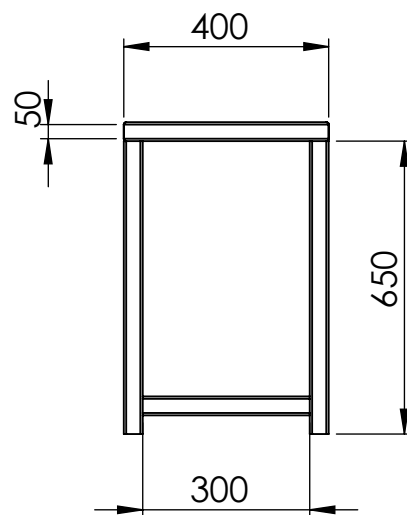
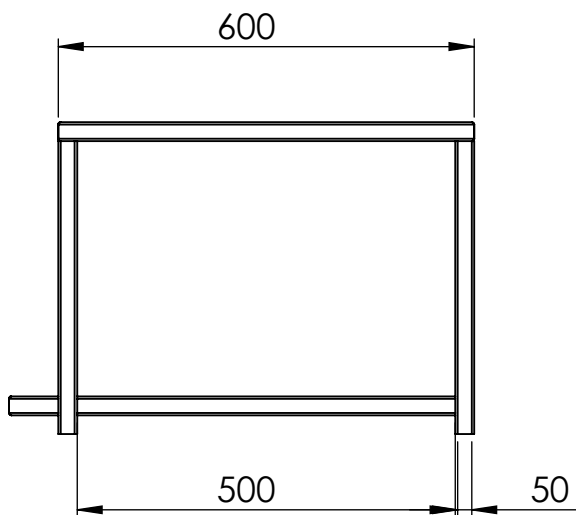
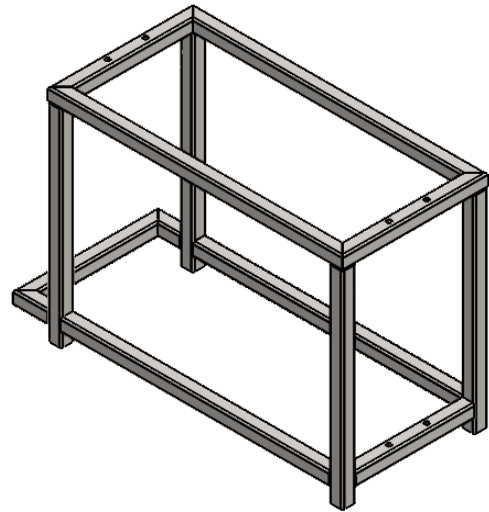
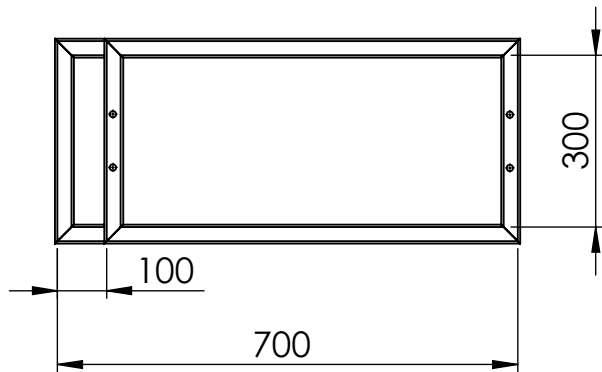
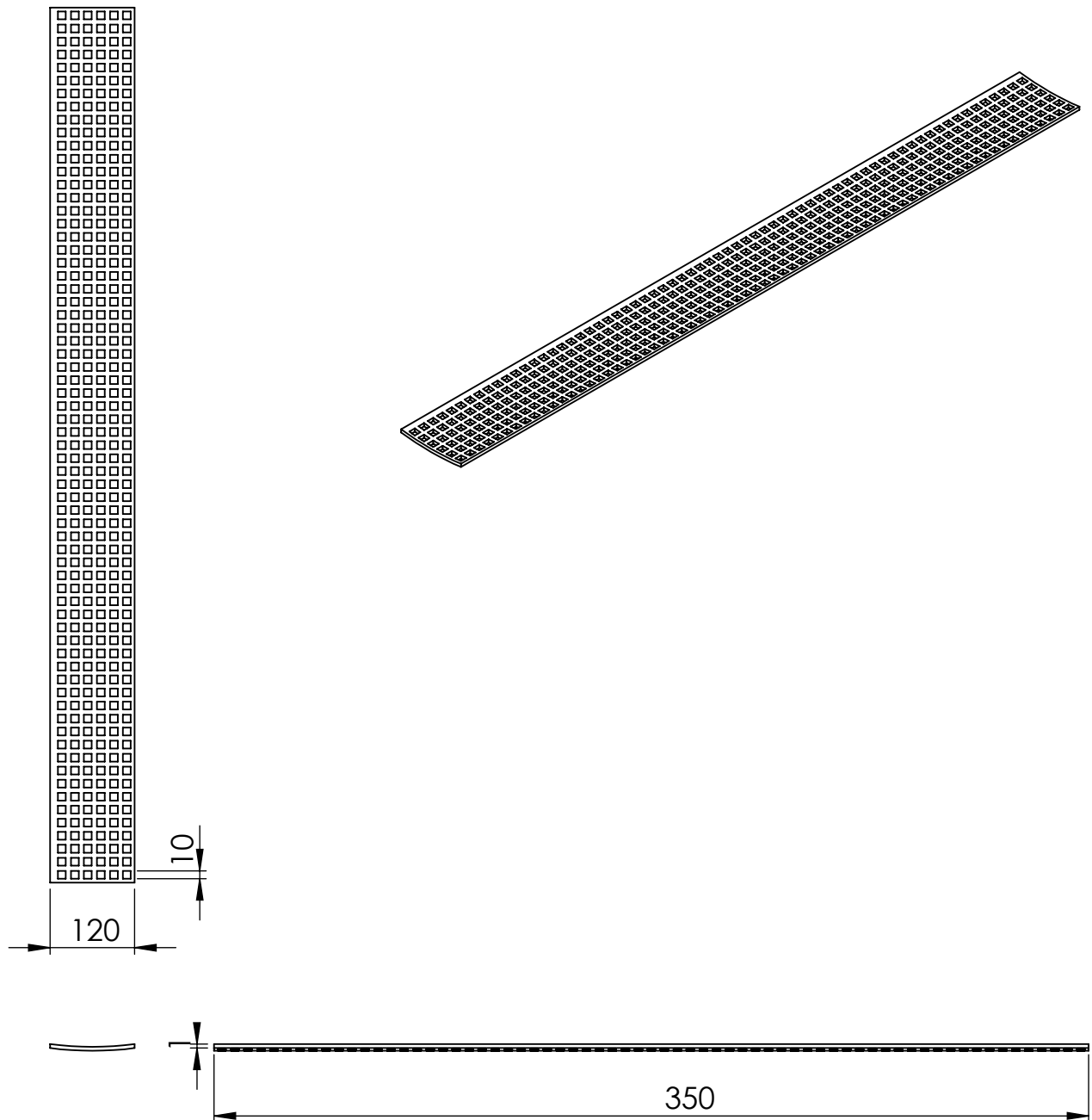


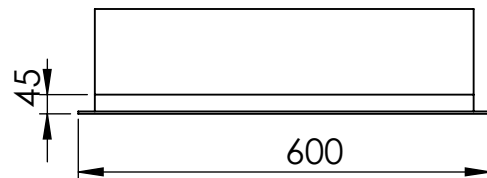
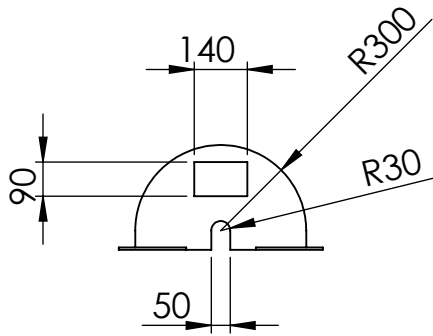
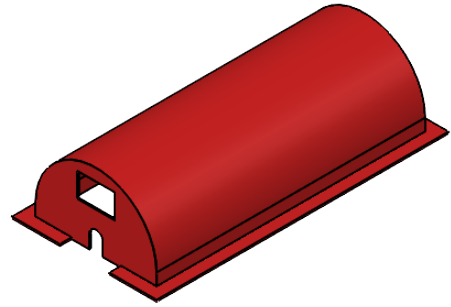
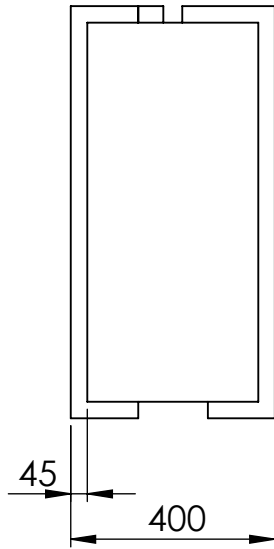
Lampiran 1 Gambar Teknik



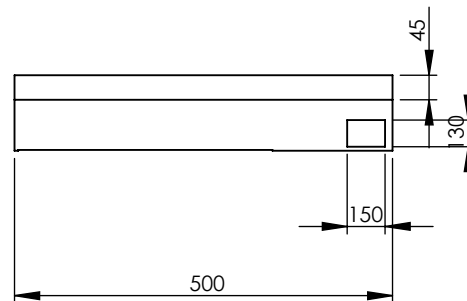
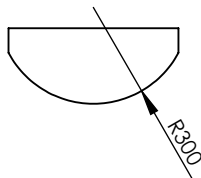
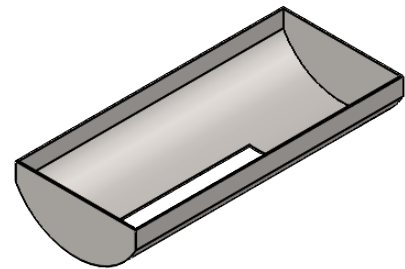
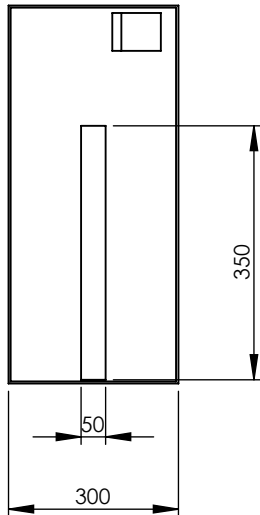
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POLITEKNIK NEGERI CILACAP									FORMAT A4	NO. GAMBAR	



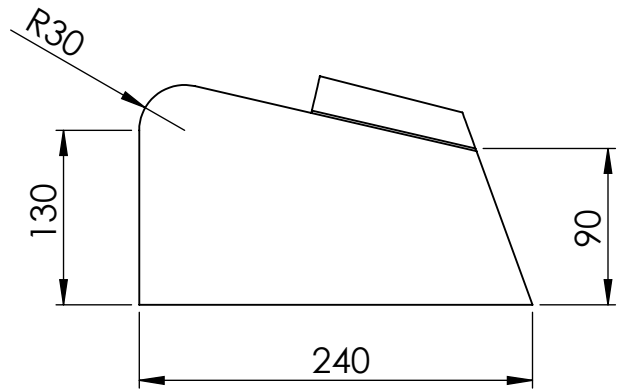
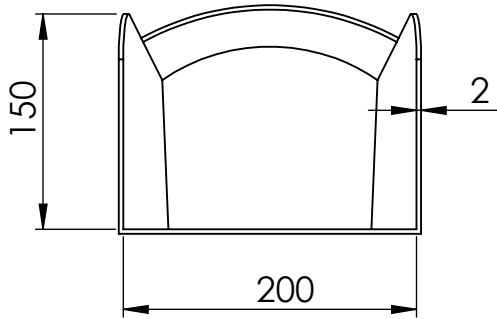
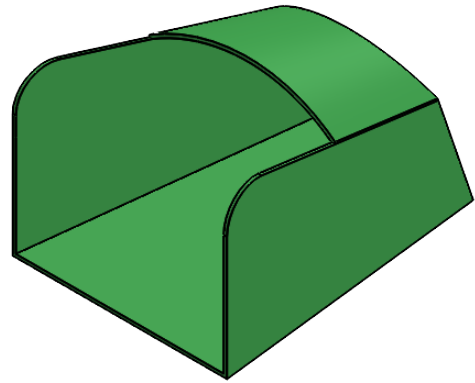
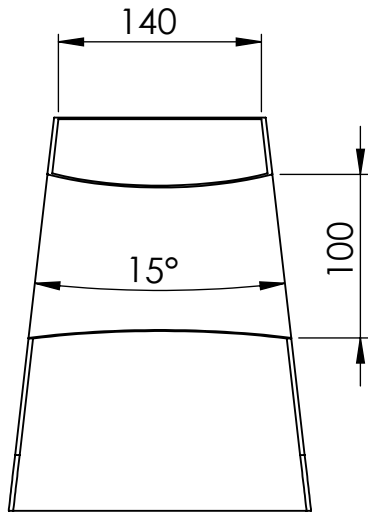
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TOL	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2					
PENYARING COCOPEAT								SKALA	DIGAMBAR	PRAS	
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POLITEKNIK NEGERI CILACAP								FORMAT	NO. GAMBAR		
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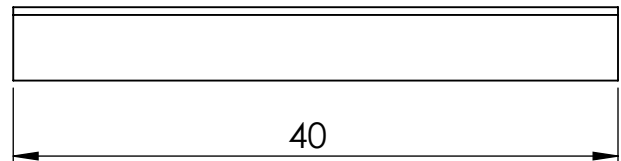
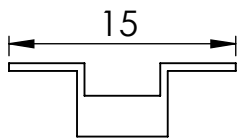
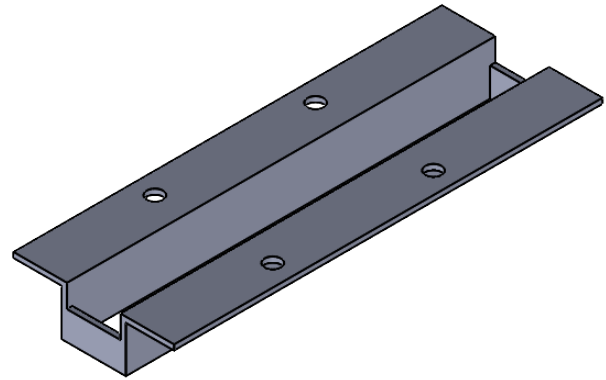
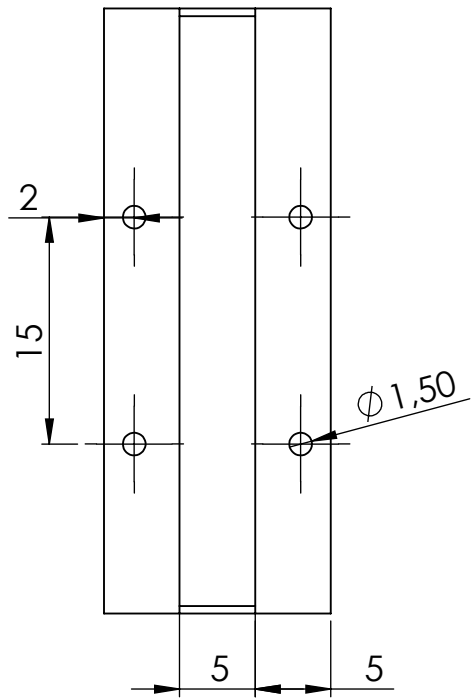
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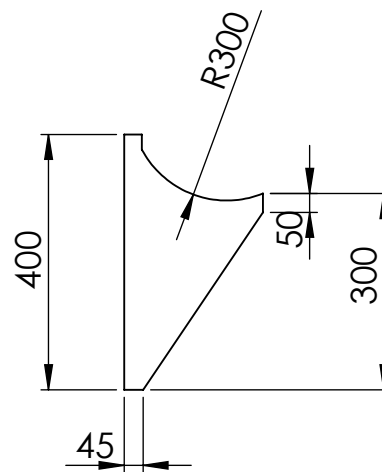
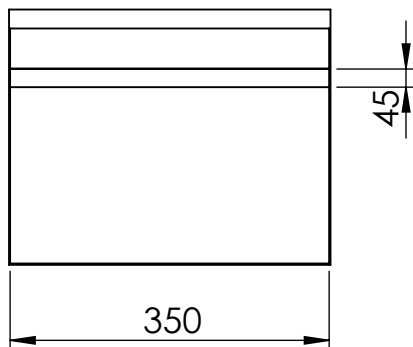
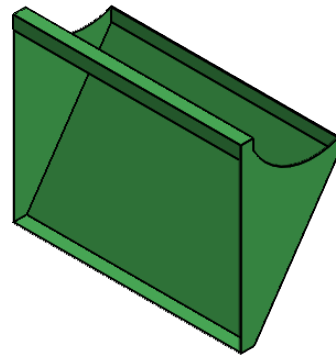
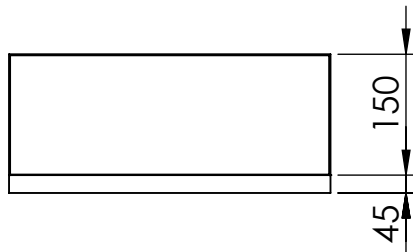
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TOL	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2						
TABUNG PENGURAI									SKALA	DIGAMBAR	PRAS	
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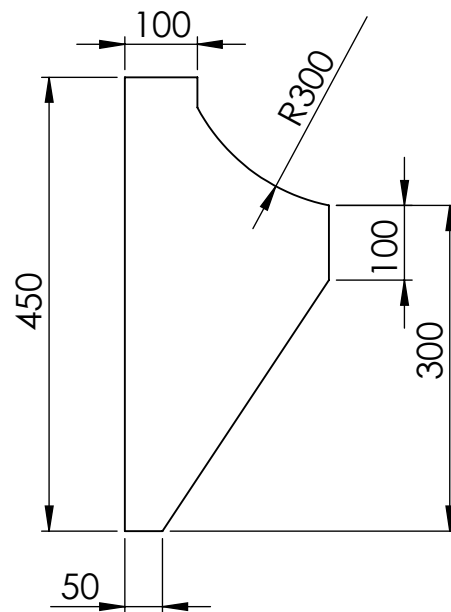
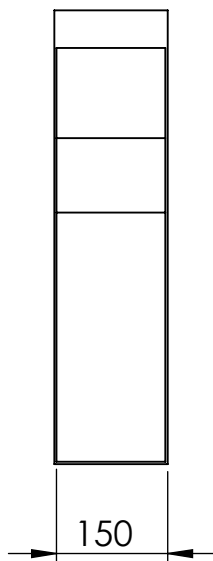
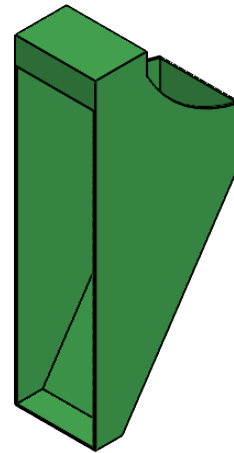
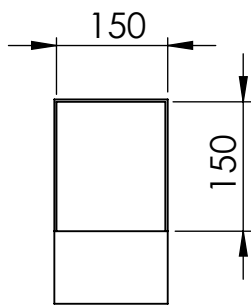
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TOL	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2					
INLET SABUT KELAPA									SKALA 1 : 5	DIGAMBAR	PRAS
									DIPERIKSA		
									DISAHKAN		
POLITEKNIK NEGERI CILACAP									FORMAT A4	NO. GAMBAR	



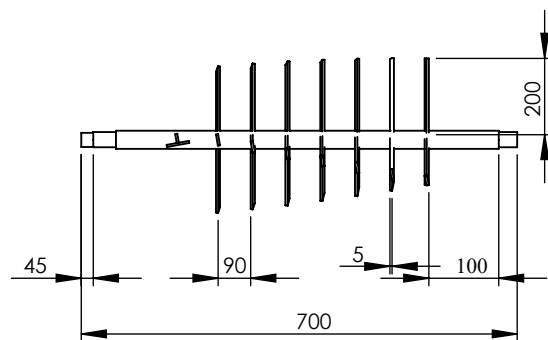
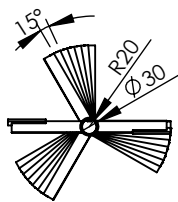
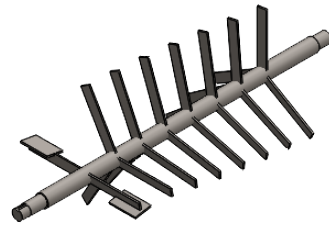
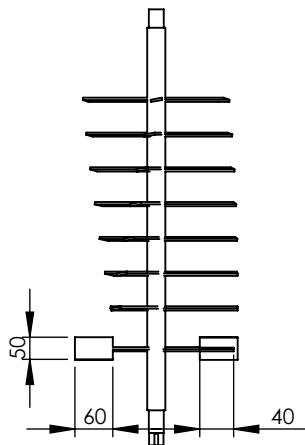
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TOL	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2						
DUDUKAN MOTOR PENGGERAK									SKALA	DIGAMBAR	PRAS	
									1:5	DIPERIKSA		
										DISAHKAN		
POLITEKNIK NEGERI CILACAP									FORMAT	NO. GAMBAR		
									A4			



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TOL	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2					
OUTPUT COCOPEAT								SKALA 1:20	DIGAMBAR	PRAS	
									DIPERIKSA		
									DISAHKAN		
POLITEKNIK NEGERI CILACAP								FORMAT A4	NO. GAMBAR		



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TOL	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2					
OUTPUT COCOFIBER									SKALA 1: 10	DIGAMBAR	PRAS
									DIPERIKSA		
									DISAHKAN		
POLITEKNIK NEGERI CILACAP									FORMAT A4	NO. GAMBAR	





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TOL	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2						
POROS DAN PISAU									SKALA	DIGAMBAR	PRAS	
									1:10	DIPERIKSA		
										DISAHKAN		
POLITEKNIK NEGERI CILACAP									FORMAT	NO. GAMBAR		
									A4			

Lampiran 2 Tabel kecepatan *spindle* mesin bubut

	1	2	3
A	60	220	860
B	92	360	1400
C	140	530	2000

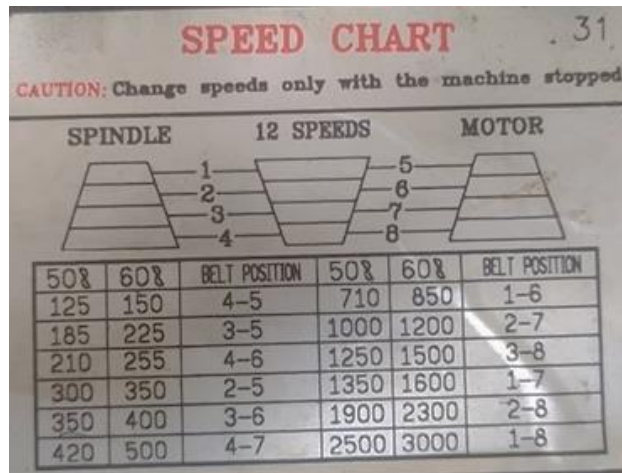
Lampiran 4 Variasi feeding mesin bubut

LONGITUDINAL FEED					TRANSVERSE FEED				
									
M	M				M	M			
	D	E	F	G		D	E	F	G
1	0.044	0.088	0.176	0.352	1	0.020	0.039	0.079	0.158
2	0.050	0.099	0.198	0.396	2	0.022	0.044	0.089	0.178
3	0.052	0.105	0.210	0.420	3	0.023	0.047	0.094	0.188
4	0.055	0.110	0.220	0.440	4	0.024	0.049	0.098	0.196
5	0.060	0.121	0.242	0.484	5	0.027	0.054	0.109	0.218
6	0.063	0.127	0.254	0.508	6	0.028	0.057	0.114	0.228
7	0.066	0.132	0.264	0.528	7	0.029	0.059	0.118	0.236
8	0.072	0.144	0.287	0.574	8	0.032	0.064	0.128	0.256
9	0.075	0.149	0.298	0.596	9	0.033	0.067	0.134	0.268
10	0.077	0.154	0.308	0.616	10	0.034	0.069	0.138	0.276
11	0.083	0.166	0.331	0.662	11	0.037	0.074	0.148	0.296

Lampiran 5 Tabel data material dan Tabel kecepatan *spindle* mesin gurdi

MATERIAL	CUTTING SPEEDS 1.		POINT ANGLE	LIP CLEARANCE	COOLANTS
	(METERS/MINUTE)	(FEET/MINUTE)			
Aluminum And Alloys	61.00 - 91.50	200 - 300	90 - 130 deg	12 - 15 deg	Kerosene/Kerosene & Lard Oil/ Soluble Oil
Armor Plate	12.20 - 18.25	40 - 50	135 - 140 deg	6 - 9 deg	Light Machine Oil
Brass	61.00 - 91.50	200 - 300	118 - 118 deg	12 - 15 deg	Dry/ Soluble Oil/Kerosene/Lard Oil
Bronze	61.00 - 91.50	200 - 300	110 - 118 deg	12 - 15 deg	Dry/ Soluble Oil/Mineral Oil/Lard Oil
Bronze, High Tensile	21.35 - 45.75	70 - 150	100 - 110 deg	12 - 15 deg	Dry/ Soluble Oil/Mineral Oil/Lard Oil
Cast Iron, Soft	30.50 - 45.75	100 - 150	90 - 100 deg	12 - 15 deg	Air Jet Dry/ Soluble Oil
Cast Iron, Medium	21.35 - 30.50	70 - 100	100 - 110 deg	12 - 15 deg	Air Jet Dry/ Soluble Oil
Cast Iron, Hard	21.35 - 30.50	70 - 100	100 - 118 deg	8 - 12 deg	Air Jet Dry/ Soluble Oil
Cast Iron, Chilled	9.15 - 12.20	30 - 40	118 - 135 deg	5 - 9 deg	Air Jet Dry/ Soluble Oil
Copper	61.00 - 91.50	200 - 300	100 - 118 deg	12 - 15 deg	Air Jet Dry/ Soluble Oil
Copper Graphite Alloy (Carbon Drills)	18.30 - 21.35	60 - 70	**_**	**_**	Soluble Oil/Dry/Mineral Oil/Kerosene
Glass (Carbon Drills)	6.10 - 9.15	20 - 30	**_**	**_**	Soluble Oil/Dry/Mineral Oil/Kerosene
Iron, Malleable	15.25 - 27.45	50 - 90	90 - 100 deg	12 - 15 deg	Light Machine Oil
Magnesium And Alloys	76.25 - 122.0	250 - 400	70 - 118 deg	12 - 15 deg	Soluble Oil
Monel Nickel	4.15 - 15.28	30 - 50	118 - 125 deg	10 - 12 deg	Compressed Air/Mineral Oil
Nickel Alloys	12.20 - 18.30	40 - 60	135 - 140 deg	5 - 7 deg	Lard Oil/Soluble Oil
Plastic, Hot Set	30.50 - 91.50	100 - 300	60 - 90 deg	10 - 12 deg	Lard Oil/Soluble Oil
Plastic, Cold Set	30.50 - 91.50	100 - 300	118 - 135 deg	12 - 20 deg	Soap Solution
Steel, Low Carbon, 0.2-0.3ct	24.40 - 33.55	80 - 110	110 - 118 deg	7 - 9 deg	Soap Solution
Steel, Medium Carbon 0.4-0.5c	21.35 - 24.40	70 - 80	118 - 125 deg	7 - 9 deg	Soluble Oil/Mineral Oil/Sulfur Oil/Lard Oil
Steel (High Carbon 1.2c)	15.25 - 18.30	50 - 60	118 - 145 deg	7 - 9 deg	Soluble Oil/Mineral Oil/Sulfur Oil/Lard Oil
Steel, Forged	15.25 - 18.30	50 - 60	118 - 145 deg	7 - 12 deg	Soluble Oil/Mineral Oil/Sulfur Oil/Lard Oil
Steel, Alloy	15.25 - 21.35	50 - 70	118 - 125 deg	10 - 12 deg	Mineral Lard Oil
Steel, Alloy 300 To 400 Brinell	6.10 - 9.15	20 - 30	130 - 140 deg	7 - 10 deg	Soluble Oil
Steel, Stainless, Free Machining	9.15 - 24.40	30 - 80	110 - 118 deg	8 - 12 deg	Soluble Oil
Steel, Stainless, Hard	4.57 - 15.25	15 - 50	118 - 135 deg	6 - 8 deg	Soluble Oil
Steel, Manganese	3.66 - 4.57	12 - 15	140 - 150 deg	7 - 10 deg	Soluble Oil
Stone (Carbide Drills)	7.63 - 9.15	25 - 30	**_**	**_**	Water Solution
Wood	91.50 - 122.2	300 - 400	60 - 70 deg	10 - 15 deg	Dry

Gambar 1A Tabel data material



Gambar 2A Tabel kecepatan *spindle* mesin gurdi

Lampiran 6 Proses Produksi





BIODATA PENULIS



Nama : Yozif Ali Akbar
Tempat/Tanggal Lahir : Cilacap, 25 Januari 2004
Alamat : Jl. Angsana Rt05/04 Kel.Tritih Kulon Kec.Cilacap Utara
Kab. Cilacap
E-mail : yozifaliakbar@gmail.com
Nomor Handphone : +6281325593069
Hobi : Memancing
Motto : 1. *Work until you dont have to introduce yourself*
2. Jangan malas bekerja karena belum ada ninja dan R35
terparkir didepan teras.

Riwayat Pendidikan :

- SD Negeri Tritih Kulon 05 : Tahun 2009-2015
- SMP Negeri 01 Jeruklegi : Tahun 2015-2018
- SMK Boedi Oetomo Cilacap : Tahun 2018-2021
- Politeknik Negeri Cilacap : Tahun 2021-2024